

# Work Order ID 76378

**\*76378\***

Page 1

November-11-11 9:18:02 AM

Item ID: D2574 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Saddle, Aft In 205  
 Start Date: 11/11/2011 Start Qty: 6.00 **\*6\*** Cust Item ID:  
 Required Date: 18/11/2011 Req'd Qty: 6.00 **\*6\*** Customer:  
 Reference:

Approvals: Process Plan: M.L.J Date: 11/11/11 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr                       | Revision Nbr             |                      |         |        |              |               |               |                  |                |
| D2574                          | Rev E                    |                      |         |        |              |               |               |                  |                |

100 HAAS CNC VERTICAL MACHINING #1 0.00  
**\*100\*** *and 11/11/14* 6 0  
 HAAS 1 Memo 0.00  
 HAAS CNC vertical machine #1 Program Batch No. 76378 Double check by: 4 1-Machine Step  
 No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine  
 Step No 2 per Folio FA051 and inspect per attached Dimension Sheets3-  
 Machine Step No 3 per Folio FA051 and insp

110 CONVENTIONAL MILLING MACHINE 0.00  
**\*110\*** *and 11/11/22* 6 0  
 Mill Conv Memo 0.00  
 Conventional Milling Machine Machine keyway as per dwg D2573 & D2574

120 QC2- Inspect parts off machine FAI/FAIB 0.00  
**\*120\*** *and 11/11/14* 6 0  
 QC Memo 0.00  
 Quality Control

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Work Order ID 76378

**\*76378\***

Page 2

November-11-11 9:18:02 AM

Item ID: D2574 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Saddle, Aft In 205  
 Start Date: 11/11/2011 Start Qty: 6.00 **\*6\*** Cust Item ID:  
 Required Date: 18/11/2011 Req'd Qty: 6.00 **\*6\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

|     |                                   |      |    |          |  |   |  |  |  |
|-----|-----------------------------------|------|----|----------|--|---|--|--|--|
| 130 | QC8- Inspect parts - second check | 0.00 | JL | 11-11-23 |  | 6 |  |  |  |
|-----|-----------------------------------|------|----|----------|--|---|--|--|--|

**\*130\***

QC Memo

Quality Control

|     |   |      |  |  |  |  |  |  |  |
|-----|---|------|--|--|--|--|--|--|--|
| 140 | Chemical Conversion Coat per QSI005 4.1 | 0.00 |  |  |  |  |  |  |  |
|-----|---|------|--|--|--|--|--|--|--|

**\*140\***

HandFinish Memo

Hand Finishing

|     |  |      |  |  |  |  |  |  |  |
|-----|--|------|--|--|--|--|--|--|--|
| 150 | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum | 0.00 |  |  |  |  |  |  |  |
|-----|--|------|--|--|--|--|--|--|--|

**\*150\***

Powdercoat Memo

Powder Coating

START TIME: 10:15 FINISH TIME: 10:45 OVEN TEMPERATURE:

W118434

3200F

10-45

6XØ M-L 11/11/23

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**Work Order ID 76378****\*76378\***

Page 3

November-11-11 9:18:02 AM

Item ID: D2574

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Saddle, Aft In 205

Start Date: 11/11/2011 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 18/11/2011 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

160 QC3- Inspect Part Finish

0.00

**\*160\***

QC

Memo

0.00

Quality Control

6 BL 11-11-23

170 Identify as per dwg & Stock Location: **ST 435**

0.00

**\*170\***

Packaging

Memo

0.00

Packaging

⑥ Sp 11-11-23

180 QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

Memo

0.00

Quality Control

u/u/23  
mrc  
11-11-23

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

November-11-11 9:18:06 AM

Page 1

Work Order ID: 76378

**\*76378\***

Parent Item: D2574

**\*D2574\***

Parent Item Name: Saddle, Aft In 205

Start Date: 11/11/2011

Required Date: 18/11/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev: I As Per RevE 06-01-27 JLM

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D6101-005                       |                        | Manufactured  | No          |                     |                  | 110             | Each               | 67.0000        | 1           | 6            |               |                |        |

**\*D6101-005\***

**\*\***

Saddle Billet

Location

Loc Qty

Loc Code

MAT

8

71721

8

MAT045

48

73420

40

74507

8

MAT046

11

66966

3

→ 74507

8

6 and 11/11/13

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



|   |                           |
|---|---------------------------|
| <b>DART AEROSPACE LTD</b>               | <b>Work Order:</b> 76378  |
| <b>Description:</b> Saddle, Aft Inboard | <b>Part Number:</b> D2574 |
| <b>Inspection Dwg:</b> D2574 Rev. E     | <b>Page 1 of 1</b>        |

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

| Dim           | Min   | Max   | Go/No Go Gauge | Recorded Actual Dimensions |       |       |       | By | Date |
|---------------|-------|-------|----------------|----------------------------|-------|-------|-------|----|------|
|               |       |       |                | 1                          | 2     | 3     | 4     |    |      |
| A             | 0.438 | 0.443 |                | .440                       | .440  | .440  | .440  |    |      |
| B             | 1.745 | 1.755 |                | 1.750                      | 1.750 | 1.750 | 1.750 |    |      |
| C             | 3.495 | 3.505 |                | 3.500                      | 3.500 | 3.500 | 3.500 |    |      |
| D             | 1.745 | 1.755 |                | 1.750                      | 1.750 | 1.750 | 1.750 |    |      |
| E             | 7.990 | 8.010 |                | 8.001                      | 8.001 | 8.001 | 8.001 |    |      |
| F             | 0.490 | 0.510 |                | .501                       | .501  | .503  | .501  |    |      |
| G             | 0.257 | 0.262 |                | .259                       | .259  | .259  | .259  |    |      |
| H             | 0.375 | 0.380 |                | .377                       | .377  | .377  | .377  |    |      |
| I             | 0.490 | 0.510 |                | .502                       | .502  | .503  | .503  |    |      |
| J             | 1.174 | 1.184 |                | 1.179                      | 1.179 | 1.179 | 1.179 |    |      |
| K             | 0.558 | 0.578 |                | .570                       | .569  | .571  | .571  |    |      |
| L             | 1.174 | 1.184 |                | 1.179                      | 1.179 | 1.179 | 1.179 |    |      |
| M             | 1.365 | 1.375 |                | 1.370                      | 1.370 | 1.370 | 1.370 |    |      |
| N             | 2.495 | 2.505 |                | 2.500                      | 2.500 | 2.500 | 2.500 |    |      |
| O             | 4.119 | 4.129 |                | 4.124                      | 4.124 | 4.124 | 4.124 |    |      |
| P             | 0.115 | 0.135 |                | .126                       | .125  | .126  | .125  |    |      |
| Q             | 0.115 | 0.135 |                | .135                       | .135  | .135  | .135  |    |      |
| R             | 0.240 | 0.260 |                | .249                       | .249  | .249  | .249  |    |      |
| S             | 0.115 | 0.135 |                | .132                       | .130  | .130  | .131  |    |      |
| T             | 0.178 | 0.198 |                | .188                       | .188  | .188  | .188  |    |      |
| U             | 3.210 | 3.250 |                | 3.230                      | 3.230 | 3.230 | 3.230 |    |      |
| V             | 0.230 | 0.250 |                | .238                       | .236  | .236  | .237  |    |      |
| W             | 0.115 | 0.135 |                | .132                       | .132  | .130  | .131  |    |      |
| X             | 0.307 | 0.312 |                | .311                       | .311  | .311  | .312  |    |      |
| Y             | 0.760 | 0.765 |                | .763                       | .764  | .762  | .762  |    |      |
| Z             | 0.352 | 0.372 |                | .363                       | .361  | .362  | .362  |    |      |
| AA            | 0.470 | 0.530 |                | .500                       | .500  | .500  | .500  |    |      |
| AB            | 0.615 | 0.635 |                | .627                       | .627  | .627  | .627  |    |      |
| AC            | 0.053 | 0.073 |                | .063                       | .063  | .063  | .063  |    |      |
| AD            | 0.240 | 0.260 |                | .248                       | .247  | .245  | .247  |    |      |
| AE            | 1.500 | 1.520 |                | 1.505                      | 1.515 | 1.515 | 1.515 |    |      |
| AF            | 0.115 | 0.135 |                | .135                       | .135  | .135  | .135  |    |      |
| AG            | 0.240 | 0.280 |                | .275                       | .275  | .275  | .275  |    |      |
| AH            | 0.240 | 0.260 |                | .248                       | .247  | .246  | .247  |    |      |
| AI            | 2.000 | 2.020 |                | 2.002                      | 2.003 | 2.003 | 2.003 |    |      |
| AJ            | 0.023 | 0.043 |                | .033                       | .033  | .033  | .033  |    |      |
| Accept/Reject |       |       |                |                            |       |       |       |    |      |

|              |                    |
|--------------|--------------------|
| Measured by: | <i>[Signature]</i> |
| Date:        | 11/11/14           |

|             |                    |
|-------------|--------------------|
| Audited by: | <i>[Signature]</i> |
| Date:       | 11-11-23           |

| Rev | Date     | Change                                  | Revised by | Approved           |
|-----|----------|---|------------|--------------------|
| A   |          | New Issue                               | RF         |                    |
| B   | 02.09.27 | Re-format; Added Rev. D                 | KJ         |                    |
| C   | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ         |                    |
| D   | 05.05.05 | Added dimension AI                      | KJ/RF      |                    |
| E   | 05.12.05 | Added dimension AJ                      | KJ/JLM     | <i>[Signature]</i> |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

|   |  |                           |
|---|--|---------------------------|
| <b>DART AEROSPACE LTD</b>               |  | <b>Work Order:</b> 76398  |
| <b>Description:</b> Saddle, Aft Inboard |  | <b>Part Number:</b> D2574 |
| <b>Inspection Dwg:</b> D2574 Rev. E     |  | <b>Page 1 of 1</b>        |

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

|               |       |       |                | Recorded Actual Dimensions |       |   |   | By | Date |
|---------------|-------|-------|----------------|----------------------------|-------|---|---|----|------|
| Dim           | Min   | Max   | Go/No Go Gauge | 1/5                        | 2/6   | 3 | 4 |    |      |
| A             | 0.438 | 0.443 |                | .440                       | .440  |   |   |    |      |
| B             | 1.745 | 1.755 |                | 1.750                      | 1.750 |   |   |    |      |
| C             | 3.495 | 3.505 |                | 3.500                      | 3.500 |   |   |    |      |
| D             | 1.745 | 1.755 |                | 1.750                      | 1.750 |   |   |    |      |
| E             | 7.990 | 8.010 |                | 8.001                      | 8.001 |   |   |    |      |
| F             | 0.490 | 0.510 |                | .501                       | .501  |   |   |    |      |
| G             | 0.257 | 0.262 |                | .259                       | .259  |   |   |    |      |
| H             | 0.375 | 0.380 |                | .377                       | .377  |   |   |    |      |
| I             | 0.490 | 0.510 |                | .504                       | .503  |   |   |    |      |
| J             | 1.174 | 1.184 |                | 1.179                      | 1.179 |   |   |    |      |
| K             | 0.558 | 0.578 |                | .570                       | .570  |   |   |    |      |
| L             | 1.174 | 1.184 |                | 1.179                      | 1.179 |   |   |    |      |
| M             | 1.365 | 1.375 |                | 1.370                      | 1.370 |   |   |    |      |
| N             | 2.495 | 2.505 |                | 2.500                      | 2.500 |   |   |    |      |
| O             | 4.119 | 4.129 |                | 4.124                      | 4.124 |   |   |    |      |
| P             | 0.115 | 0.135 |                | .125                       | .125  |   |   |    |      |
| Q             | 0.115 | 0.135 |                | .135                       | .135  |   |   |    |      |
| R             | 0.240 | 0.260 |                | .250                       | .249  |   |   |    |      |
| S             | 0.115 | 0.135 |                | .130                       | .130  |   |   |    |      |
| T             | 0.178 | 0.198 |                | .188                       | .188  |   |   |    |      |
| U             | 3.210 | 3.250 |                | 3.230                      | 3.230 |   |   |    |      |
| V             | 0.230 | 0.250 |                | .238                       | .239  |   |   |    |      |
| W             | 0.115 | 0.135 |                | .132                       | .131  |   |   |    |      |
| X             | 0.307 | 0.312 |                | .312                       | .312  |   |   |    |      |
| Y             | 0.760 | 0.765 |                | .762                       | .762  |   |   |    |      |
| Z             | 0.352 | 0.372 |                | .362                       | .361  |   |   |    |      |
| AA            | 0.470 | 0.530 |                | .500                       | .500  |   |   |    |      |
| AB            | 0.615 | 0.635 |                | .627                       | .627  |   |   |    |      |
| AC            | 0.053 | 0.073 |                | .063                       | .063  |   |   |    |      |
| AD            | 0.240 | 0.260 |                | .247                       | .247  |   |   |    |      |
| AE            | 1.500 | 1.520 |                | 1.511                      | 1.510 |   |   |    |      |
| AF            | 0.115 | 0.135 |                | .135                       | .135  |   |   |    |      |
| AG            | 0.240 | 0.280 |                | .275                       | .275  |   |   |    |      |
| AH            | 0.240 | 0.260 |                | .248                       | .249  |   |   |    |      |
| AI            | 2.000 | 2.020 |                | 2.003                      | 2.002 |   |   |    |      |
| AJ            | 0.023 | 0.043 |                | .033                       | .033  |   |   |    |      |
| Accept/Reject |       |       |                |                            |       |   |   |    |      |

|                         |                       |
|-------------------------|-----------------------|
| Measured by: <i>omf</i> | Audited by: <i>JK</i> |
| Date: 11/11/15          | Date: 11-11-23        |

| Rev | Date     | Change                                  | Revised by | Approved  |
|-----|----------|---|------------|-----------|
| A   |          | New Issue                               | RF         |           |
| B   | 02.09.27 | Re-format; Added Rev. D                 | KJ         |           |
| C   | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ         |           |
| D   | 05.05.05 | Added dimension AI                      | KJ/RF      |           |
| E   | 05.12.05 | Added dimension AJ                      | KJ/JLM     | <i>JK</i> |

RELEASED

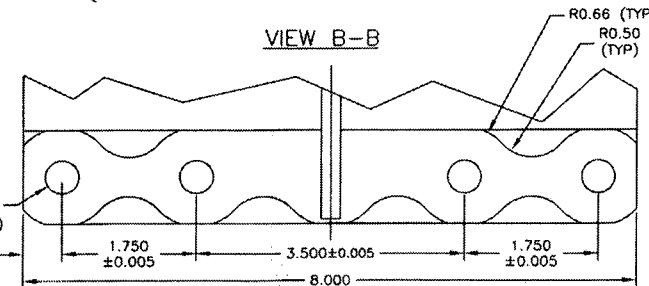
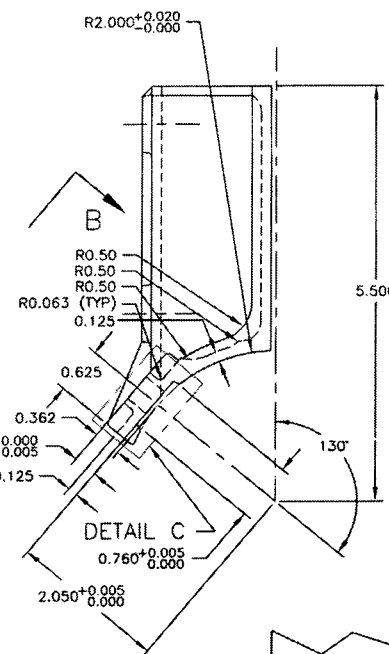
05.12.06

# NOTES

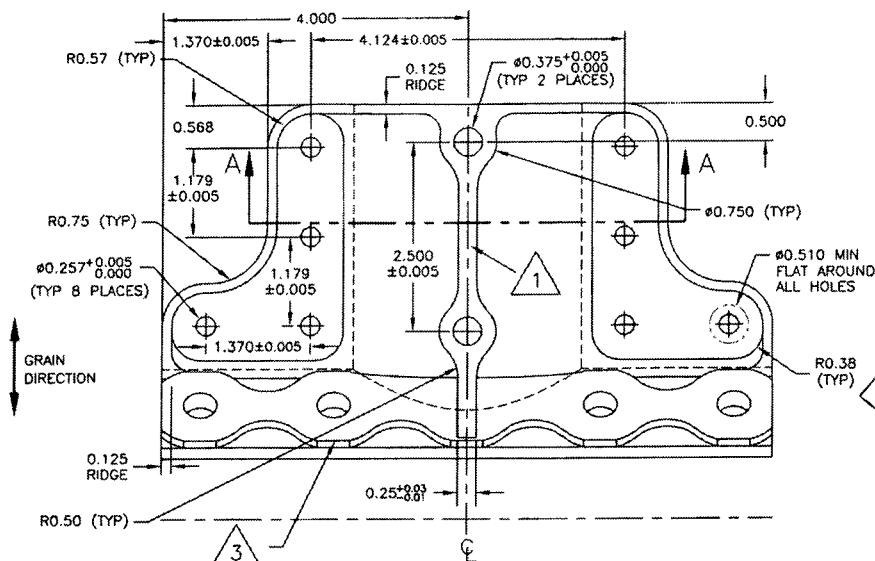
MATERIAL: 7075-T7351 (QQ-A-250/12)  
(REF DART SPEC. D6102-003)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C)

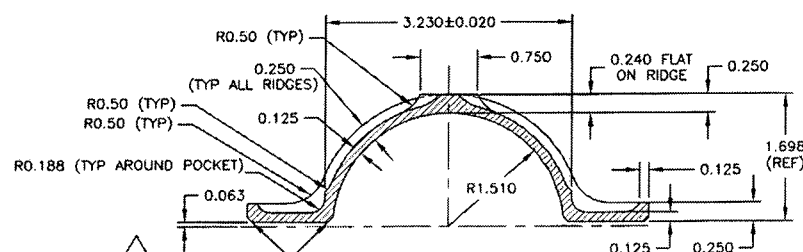
## VIEW B-B



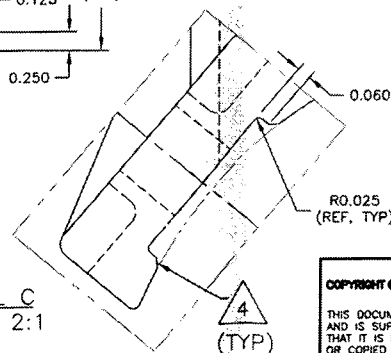
|             |                     |  |
|-------------|---------------------|--|
| E           | 05.07.13            | ADD CHAMFER ON RIDGE NOTE 4                                |
| D           | 02.09.06            | ADD RIDGES; TIGHTEN TOLERANCES                             |
| C           | 99.10.22            | INCORP. DEO 9123/9079/9102<br>ADD DIMENSIONS PER TSR A1177 |
| B           | 96.12.02            | ADD GRAIN DIR., 0.438 WAS 0.425                            |
| A           | 96.09.16            | NEW ISSUE  |
| DESIGN      | DS                  | DRAWN BY PH  |
| CHECKED     | PH                  | APPROVED PH  |
| DATE        | 05.07.13            | TITLE INNER AFT SADDLE                                     |
| DART        | DART AEROSPACE LTD. | REVISIONS  |
| DRAWING NO. | D2574               | REV. E   |
| SHEET       | 1 OF 1              | SCALE 2:3  |



## SECTION A-A



## DETAIL C SCALE 2:1



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WORK ORDER  
NO. 76378 M.C.J.  
11/11/11

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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries